

Work Order ID 79741

June-19-12 11:23:44 AM

79741

Page 1

Item ID: D6019-128

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Material

Start Date: 2/01/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/16/12

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6019

Rev A

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 16063 a) Order as per Dwg D6019 b) Material: 2.750 x 0.313 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d) Minimum tensile yield strength = 66 ks

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure material certification is attached

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Ensure Material certification comply to Dwg D6005

12-01-02

12/8/26 (10)

AS Per DS Enroll

Schwarz

(A)

Work Order ID 79741

79741

Page 2

June-19-12 11:23:44 AM

Item ID: D6019-128 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Material
 Start Date: 2/01/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/16/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo N/A 9/24/13	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo N/A 9/24/13	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 46 Memo	0.00 0.00							

12-7-3
 7

See attached e-mail for QTY.
 8/12-7-3

Work Order ID 79741***79741***

Page 3

June-19-12 11:23:44 AM

Item ID: D6019-128

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Material

Start Date: 2/01/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/16/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/7/4

12-07-4

Picklist Print

June-19-12 11:23:03 AM

Page 1

Work Order ID: 79741

Parent Item: D6019-128

Start Date: 2/01/12

Required Date: 3/16/12

Parent Item Name: Crosstube Material

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev.A New Issue LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6019-128P Crosstube Material		Purchased	No				Each	17.0000		10		6/15/12	

Location

Loc Qty

Loc Code

ST

17

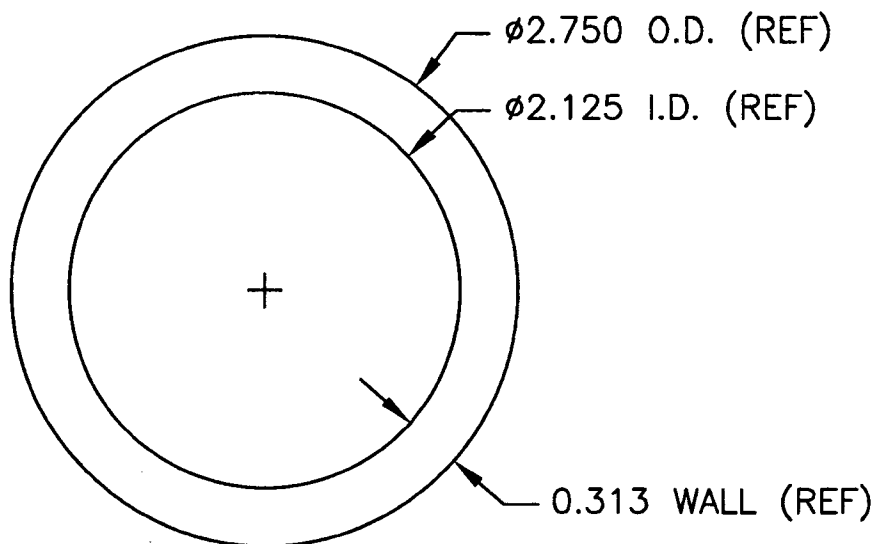
79741

17

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6019	REV. A SHEET 1 OF 1
DATE 06.11.03		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	06.11.03	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED07.04.09 *[Signature]**mtb
06/11/03*

NOTES

- 1) D6019-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6019-128

- 2) MATERIAL: 2.750 OD x 0.313 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Saturday, May 26, 2012 10:00:47 AM

All amounts are calculated in domestic currency.

Page 1 of 1

All Vendors PO ID PO#6663 Receipt Dates from 5/26/2012 to 5/26/2012 All Line Item Types
 All Item ID's All Rec. Employees All Currents
 Grouped by Vendor ID

[illegible]

06/19/2012 TUE 11:43 FAX 613 632 4443 DART HELICOPTER SERVICES

002/013

05/22/12

KATSER ALUMINUM FABRICATED PRODUCTS, LLC
PACKING LIST

PAGE 10

KATSER ALUMINUM - KALAMAZOO
5205 KATSER DRIVE
KALAMAZOO, MI 49002
DART AEROSPACE LTD
1270 ABERDEEN
STREET
HAWKESBURY ON KIR 1X7
SOLD TO
DART AEROSPACE LTD
HAWKESBURY ON KIR 1X7
INSIDE SALES REP
FACIO
BILL OF LADING
SHIP DATE
CARRIER
LOAD NUMBER
TOTAL GROSS WT
600502
05/22/12
JWS
BR47
627 LBS.
SHIPMENT NBR- 614019 0001

SHIP ITEM RELEASE	ITEM	DESCRIPTION	P.O. NUMBER	LOT NUMBER	PACKAGE NUMBER	PACK PIECES	GROSS WT	NET WT	BACK FOOTAGE ORDER
1	614019	001 SPIRIT-372415 02.875 2.905#/FT **** 707575511	COMPLETE 15053	*7072 003 Dash 0001	0000068191	5 5	180	155	53.33
2		123.0000 IN +/-2500 -0 IN VOL 1075 76513 2.750" OD X .313" WALL BA EST		7072 003 Dash 0001	0000068193	6 6	211	186	54.00
3				7072 003 Dash 0001	0000068193	3 3	138	93	32.00
4				7072 003 Dash 0001	0000068194	3 3	128	93	32.00
TOTAL:							527	527	181.33
TOTAL NET WT							527	FOOTAGE	181.33

17

releaser

* MATERIAL CERTIFICATION REQUIRED FOR THIS LOT NUMBER.

KAISER ALUMINUM FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
5205 KAISER DRIVE
KALAMAZOO, MI 49048

CUSTOMER PO NUMBER: 16088-1		CUSTOMER PART NUMBER: SPIRIT-372415		PRODUCT DESCRIPTION: 7075 T6511 2.750 OD X .313 WALL HA EST	
KAISER ORDER NUMBER: 614019	LINE ITEM: 001	SHIP DATE: 05/22/2012	KAISER LOT NUMBER: 70072 003	ALLOY: 7075	TEMPER: T6511
WEIGHT SHIPPED: 527.000 LB	QUANTITY: 17.000 PCS	BL NUMBER: 603504	DIAM/DIA/THKNS: 	WIDTH: 	LENGTH: 10.666 FT
SHIP TO: DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA			SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.
BEND							

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.10	0.50	2.00	0.30	2.90	0.28	6.10	0.20	NA	NA	NA	0.05	0.15
Minimum	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	NA	NA	NA	0.00	0.00
D33464	.08	.20	1.26	.03	2.71	.19	5.77	.02	.00	.00	.01	.01	.02

Applicable Requirements:

No Weld Repair. Mercury Free.

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

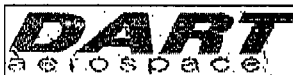
Alex Yeh, Quality & Technology Manager

Alex Yeh

Plant Serial: 00045052

Kaiser Order Number: 614019

Line Item: 001



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID: PO16063

Purchase Order Date: 2/01/12

PO Print Date: 2/14/12

Page Number: 1 of 1

Order From:

KAISER ALUMINUM
6573 W WILLIS ROAD

CHANDLER, ARIZONA 85226
USA

VU:KA1001

Contact Name

Vendor Phone: 520 796 1097 Ext. 1020

Vendor Fax: 520 796 0596

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-128P	Cross-tube Material	3/16/12 Yes	17.00 Each		\$723.9400	\$12,310.98

Special Inq: AS PER DWO D6019 REV. A
879741
MATERIAL: T6511 AS PER QQ-A-223/9
OR QQ-A-200/11
SIZE: 2.750" X 0.313" WALL, SEAMLESS
ALUMINUM TUBE
MINIMUM ULTIMATE TENSILE
STRENGTH = 77 KSI
MINIMUM TENSILE YIELD STRENGTH
= 66 KSI

NOTE: PLEASE PRODUCE IN T6511

PO Total:

\$12,310.98

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PO Instructions: quotation no. 525407

Change Nbr: 2

Change Date: 2/14/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable.

004/013

06/19/2012 TUE 11:43 FAX 613 632 4443 DART HELICOPTER SERVICES

Chantal Lavoie

From: Linda Lacelle <llacelle@dartaero.com>
Sent: February 14, 2012 10:37 AM
To: 'Facio, Nathan M.'
Cc: 'Mahan, Steve'; clavoie@dartaero.com
Subject: RE: PO 16063; Kaiser Quote 525407

Good Morning,

We are all in agreement to proceed with the new quote, and your exceptions. Please produce in T6511. Please ensure all the information we gave to Nat, gets implemented into this PO.

Chantal will be sending the revised PO shortly.

Thank You,

Linda Lacelle

Production manager

Dart Aerospace

From: Facio, Nathan M. [<mailto:Nathan.Facio@kaiserai.com>]
Sent: February-13-12 6:55 PM
To: clavoie@dartaero.com
Cc: Mahan, Steve; llacelle@dartaero.com
Subject: PO 16063; Kaiser Quote 525407

Hi Chantal Lavoie,

I have attached a copy of our Quote 525407, in pdf format. Note the price per pound and advise which temper you will want us to mfg, so we can enter this PO in our system.

- 527 lbs (17 pieces) minimum, \$23.74/lb.
- Advise on temper: T6, or T6511.

One more thing, please note on our quote the exceptions we are taking to your print: D6019-128P.

Thank you,

Nathaniel M. Facio - Inside Sales Rep
Kaiser Aluminum - 6573 W. Willis Rd - Chandler AZ 85226.
P: 520-796-3220 Plant Fax: 520-796-0596.

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KAISER ALUMINUM

QUOTATION

See additional notes at the end of this quote.

Quote Number: 826407

Date: 2/13/2012

Page: 1 of 2

Contact: CHANTAL LAVOIE

Phone:

Fax:

E-Mail: clavoie@dartaero.com

Sold To: DART AEROSPACE LTD

1270 ABERDEEN

STREET

HAWKESBURY, ON K6A 1K7

CANADA

Customer Ref:

Quote Reference:

Quote Expires: 2/13/2012

CC To: linelle@dartaero.com Steve Mahan

CC To:

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

STREET

HAWKESBURY, ON K6A 1K7

CANADA

KAISER ALUMINUM is pleased to provide the following quotation based on today's metal prices, for shipment at one time to one destination. This quotation is not a contract. Price and schedule are not firm and are subject to reconfirmation at time of order placement. Orders resulting from this quote that are accepted and approved by Kaiser will be subject to Kaiser Aluminum's standard terms and conditions of sale.

TERMS: CASH BEFORE SHIPMENT

FOB: Destination

END USE:

NOTES: LENGTH TOLERANCE: -0.000"/+0.250"

Item	Alloy	Temper	Dimensions	Length	Quantity	Unit Price	Leadtime
1	7075	T6	OD: 2.750" OD+: 0.008	128.0000 In	527 LB	\$23,740/LB	13-14 WKS ARO
			OD-: 0.008 ID: 2.125" Wall: 0.313" Wall+: 0.015 Wall-: 0.015				
			Round (RA ESRT) (Tube RA Extruded Seamless)				

Kaiser Part No.: 372414

Weight/Ft: 2.9047600

Ship Tolerance: +15%/-15%

Specification: AMS-QQ-A-200/11

Non-Stenciled

Bottom: All 4 sides

External: Cardboard box

Internal: Paper Layer Separation

Item Notes:

THIS IS THE MILL MINIMUM. D6019-1288 WITH EXCEPTIONS. WE TAKE EXCEPTION TO OD TOLERANCE AND ARE ONLY OFFERING +/-0.008" MEAN READINGS; OFFERING OVALITY OF: +/-0.015". OFFERING LENGTH TOL: -0.000/+0.250". SPEC AMS-QQ-A-200/11 ALSO APPLIES.

1A ACTUAL CHEMISTRY

\$100.000

Kaiser Aluminum

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0006/013

06/19/2012 TUE 11:44 FAX 613 632 4443 DART HELICOPTER SERVICES

For additional notes at the end of this quote.

Page: 2 of 2

\$100.000

Orders resulting from this quote will be subject to Price in Effect at the time of shipment. An energy surcharge has been applied to each pound of product produced under orders generated by this quotation and is included in the Price in Effect. Additional information with respect to the surcharge is available for your review on the Kaiser Aluminum website at: www.KaiserAluminum.com.

Fax: (520) 796-0576

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO16063

Purchase Order Date 2/01/12

PO Print Date 2/01/12

Page Number 1 of 1

Order From : VIL-KA(001)
KAISER ALUMINUM
6573 W WILLYS ROAD

CHANDLER, ARIZONA 85226
USA

Contact Name		Buyer	Channel Livels
Vendor Phone	520 796 1097 Ext.1020	Requisition Nbr	
Vendor Fax	520 796 0596	The Requisition Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-128P	Crowtube Material	3/16/12 Yes	10.00 Each		\$0.0000	\$0.00
		Special Text:	AS PER DWG D6019 REV. A R79741 MATERIAL: 7075-T6/T6511 AS PER QQ-A-424/9 OR QQ-A-300/11 SIZE: 2.750" X 0.313" WALL 86AMLESS ALUMINUM TUBE MINIMUM ULTIMATE TENSILE STRENGTH = 77 KSI MINIMUM TENSILE YIELD STRENGTH = 66 KSI				
PO Total:							\$0.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 2/01/12

Chantal Lavoie

From: Facio, Nathan M. <Nathan.Facio@kaiseral.com>
Sent: February 13, 2012 6:55 PM
To: clavoie@dartaero.com
Cc: Mahan, Steve; llacelle@dartaero.com
Subject: PO 16063; Kaiser Quote 525407
Attachments: D6019-RevA.pdf; po16063 kaiser.pdf; Quote 525407 for Dart 2-13-2012.pdf; TermsAndConditions 1.pdf

Hi Chantal Lavoie,

I have attached a copy of our Quote 525407, in pdf format. Note the price per pound and advise which temper you will want us to mfg, so we can enter this PO in our system.

- 527 lbs (17 pieces) minimum, \$23.74/lb.
- Advise on temper: T6, or T6511.

One more thing, please note on our quote the exceptions we are taking to your print: D6019-128P.

Thank you,

Nathaniel M. Facio - Inside Sales Rep
Kaiser Aluminum - 6573 W. Willis Rd - Chandler AZ 85226.
P: 520-796-3220 Plant Fax: 520-796-0596.

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 0577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16063**

Purchase Order Date 2/01/12
PO Print Date 2/01/12

Page Number 1 of 1

Order From: **KAISER ALUMINUM**
6373 W WILLIS ROAD
CHANDLER, ARIZONA 85226
USA

VII-KAI001

Contact Name
Vendor Phone 520 796 1097 Ext. 1020
Vendor Fax 520 796 0596
Vendor Account Nbr

Buyer
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency USD
FOB Destination-Colleca

Chantal Laviole

Ship To: **DART AEROSPACE LTD**
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
2/12/12

cc - mco Betty

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-128P	Crosstube Material	3/16/12 Yes	10.00 Each		\$0.0000	\$0.00

784

Special Inst: AS PER DWG D6019 REV. A
D79741
MATERIAL: 7075-T6/T6511 AS PER QQ-
A-225/9 OR QQ-A-200/11
SIZE: 2.750" X 0.313" WALL SEAMLESS
ALUMINUM TUBE
MINIMUM ULTIMATE TENSILE
STRENGTH = 77 KSI
MINIMUM TENSILE YIELD STRENGTH
= 66 KSI

PO Total: \$0.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1	Change Date: 2/01/12	No substitution or deviation without consent. Certificate of Conformity or Material Certification required when applicable
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010/013

06/19/2012 TUE 11:45 FAX 613 632 4443 DART HELICOPTER SERVICES

Linda Lacelle

From: Bill Beckett <bbeckett@darths.com>
Sent: January-30-12 9:53 AM
To: Linda Lacelle
Subject: RE: crosstube mat'l to order from Kaiser

Linda,
Just between flights, gotta run. If you think this is an appropriate trial one, go with it.
Bill

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: January 30, 2012 9:13 AM
To: Bill Beckett
Subject: RE: crosstube mat'l to order from Kaiser

So, should we go with the D6019-128??
LL

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: January-25-12 1:57 PM
To: Bill Beckett (bbeckett@dartaero.com)
Subject: crosstube mat'l to order from Kaiser

Suggest one of the following:
D6019-128
D6002-115
D6004-115

Have an email out to Alunna, but we'd better do something on these now..

~~Bill~~

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1855

326-796-1097

79741
792

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DART
Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9377
Fax: 613 632 1033

PO REPRINT

Purchase Order ID: PO16063

Purchase Order Date: 2/1/12
PO Print Date: 2/14/12

Page Number 1 of 1

Order From: KAISER ALUMINUM
6573 W WILLIS ROAD
CHANDLER, ARIZONA 85226
USA

VU-KA1001

1107358

Contact Name
Vendor Phone: 520 796 1097 Ext. 1020
Vendor Fax: 520 796 0596
Vendor Account Nbr:

Buyer
Requisition Nbr
Purchase Order Nbr: 10137-2607
Terms: ~~Net 30~~ Cash Before Shipment
Currency: USD
FOB: Destination-Collect

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DWG D6019 Rev. A With Exceptions

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfr ID	Qty Tolerance Unit of Measure	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6019-1281	Extruded Material	17.00 17.00	17.00 17.00		\$735.8400	\$12,510.98

With Exceptions

See Quote 525407

* NO Stencil
* NO Oil

Kaiser Aluminum
Resolved Order
Will Ship
Will Arrive
Thank You,
Nathan Fazio

HOT RUSH

AS PER DWG D6019 REV. A
MATERIAL: T6311 AS PER
2660 OR QQ-A-200/11
SIZE: 2.75" X 0.313" WALL
SEAMLESS ALUMINUM TUBES
MINIMUM ULTIMATE TENSILE
STRENGTH = 77 KSI
MINIMUM TENSILE YIELD
STRENGTH = 66 KSI

NOTE: PLEASE PRODUCE IN T6311

OD Tol: +/- .008" max.
Wall Tol: +/- .015" max.
Ovality: +/- .015"
Length Tol: .000" / +0.250"

AMS-QQ-A-200/11
Also conforms to QQ-A-200/11

PO Total: \$12,510.98

PO Instructions: question no. 535407

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 2/14/12

012/013

06/19/2012 TUE 11:45 FAX 613 632 4443 DART HELICOPTER SERVICES

KEEP MATERIAL DRY					Subject to Section 7 of Conditions of applicable bill of lading. If this document is to be delivered to the consignee without return to the consignor, the consignor shall sign the following statement.	
CARRIER: Read Instructions on Reverse Side for Freight Bill Payment Procedures.					PAGE 3	
STRAIGHT BILL OF LADING - SHORT FORM - ORIGINAL - NOT NEGOTIABLE					THIS IS A SHIPPING ORDER	
<p>NOTICE: This bill of lading is subject to the terms and conditions of the bill of lading, the property described below in general, except as noted (terms and conditions of conditions of packages unknown) and, unless otherwise noted, which shall remain in effect throughout this contract as existing on the date of execution of the bill of lading. The carrier agrees to carry the goods in the most direct and shortest route, subject to the necessity of obtaining clearance from the appropriate authorities, and to deliver the goods to the consignee at the place of destination, unless otherwise directed by the consignee. The carrier shall be responsible for the goods from the time of receipt until the time of delivery, and shall be liable for any loss or damage to the goods during the period of transit. The carrier shall be responsible for the goods from the time of receipt until the time of delivery, and shall be liable for any loss or damage to the goods during the period of transit. The carrier shall be responsible for the goods from the time of receipt until the time of delivery, and shall be liable for any loss or damage to the goods during the period of transit.</p>					SIGNATURE OF CONSIGNEE	
<p>On delivery of the goods, the consignee shall sign the bill of lading and return it to the carrier. The carrier shall be responsible for the goods from the time of receipt until the time of delivery, and shall be liable for any loss or damage to the goods during the period of transit.</p>					<p>WHERE THE RATE IS DEPENDENT ON VALUE, THE CARRIER'S LIABILITY SHALL BE LIMITED TO THE GROSS VALUE OF THE PROPERTY IF NOT IN EXCESS OF</p>	
<p>DATE: May 22/12</p>					<p>PER</p>	
<p>From KAISER ALUMINUM ENGINEERING PRODUCTS, Shipper Per</p>					<p>PRO NO.</p>	
ORDER NO.	BUYER'S ORDER NO.	REFERS TO MASTER B/L NO.	DATE SHIPPED	Shipper's B/L No.		
X BN47			5/22/12	603504		
CONSIGNEE TO:			DATE OF TRAILER NO.	7011		
INSTRUCTIONS:			Mode	NUMBER OF USE	PREPARED	CARRIER
			SA	OF		
H	NO OF PKGS	KIND OF PACKAGES, DESCRIPTION OF ARTICLES, SPECIAL MARKS & EXCEPTIONS	SHIPPER'S WEIGHT	CHARGES COMPUTED ON	RATE	RATE CODE
M						
	5	<p>SHAPES LINEAL EXTRUDED, ALUM WGT= 2935</p> <p>NO 1, NMFC 13515-1</p> <p>CLASS 60, 45 - 30 M, NER2520</p> <p>CLASS STCC 33-529-25 UFC 5693</p> <p>*****</p> <p>STOP AT DART AEROSPACE LTD</p> <p>1270 ABERDEEN STREET</p> <p>HAWKESBURY ON KGA 1K7</p> <p>No Delivery Appointment Necessary</p> <p>Contact * Broker: Kuehne and Nagel. Contact Spiros 613-736-7424 or 514-397-9900. Deliver Mon Thru Thu No Friday 6:00 AM - 6:00 PM; Friday Hours: 6:00 AM PM.</p>				
	4	<p>SHAPES LINEAL EXTRUDED, ALUM WGT= 627</p> <p>NO 1, NMFC 13515-1</p> <p>CLASS 60, 45 - 30 M, NER2520</p> <p>CLASS STCC 33-529-25 UFC 5693</p>				
<p>This is to certify that the above named goods are properly described, packaged, marked and numbered and are in conformity with the description appearing in the applicable regulations of the Department of Transportation.</p>						
Total No of Pkgs			Total Weight			
			CONTINUED			

Eric Downing

From: Patrick Smith <psmith@dartaero.com>
Sent: Wednesday, June 20, 2012 7:16 AM
To: 'David Shepherd'; 'Eric Downing'
Cc: cprovencal@dartaero.com; 'Bill Beckett'; 'Linda Lacelle'; 'Isam El-Kassis'
Subject: RE: B79741.xlsx

Eric,
Package up the Tube which is being returned to Kaiser and have the Tubes which David has permitted to be used for production identified and stored by the production group.
Thanks,
Pat

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: June-19-12 6:53 AM
To: 'Patrick Smith'; 'Eric Downing'
Cc: cprovencal@dartaero.com; 'Bill Beckett'; 'Linda Lacelle'
Subject: RE: B79741.xlsx

Pat/Eric,

Re-arranged the data a bit into the table below with my recommended dispositions. Basically recommend keeping anything with minimum OD above (or close to) 2.738 since dwg D6019 requires OD to be 2.75 +/- 0.012 including ovality. Therefore ... recommend keeping 7 tubes and returning the other 10 to Kaiser.

David

Tube	A 0	A 180	B 0	B180	MID 0	MID 180	Disposition
1	2.738	2.750	2.737	2.740	2.738	2.749	Keep
2	2.745	2.753	2.738	2.749	2.742	2.751	Keep
3	2.738	2.753	2.741	2.751	2.745	2.753	Keep
4	2.717	2.771	2.740	2.750	2.742	2.750	Return
5	2.739	2.748	2.738	2.754	2.740	2.747	Keep
6	2.738	2.750	2.738	2.754	2.741	2.750	Keep
7	2.736	2.751	2.735	2.765	2.732	2.758	Return
8	2.738	2.750	2.735	2.756	2.734	2.756	Return
9	2.736	2.751	2.734	2.754	2.741	2.749	Return
10	2.739	2.753	2.739	2.745	2.737	2.753	Keep
11	2.719	2.773	2.737	2.747	2.739	2.749	Return
12	2.734	2.751	2.738	2.751	2.738	2.760	Return
13	2.736	2.740	2.738	2.743	2.734	2.744	Return
14	2.742	2.743	2.738	2.748	2.738	2.745	Keep
15	2.731	2.755	2.736	2.747	2.731	2.758	Return
16	2.739	2.756	2.735	2.751	2.742	2.762	Return
17	2.741	2.748	2.733	2.756	2.743	2.745	Return

From: Patrick Smith [<mailto:psmith@dartaero.com>]

Sent: June-14-12 8:42 AM

To: cprovencal@dartaero.com; Eric Downing

Cc: dshepherd@dartaero.com

Subject: B79741.xlsx

Hi Chris,

Attached is the Kaiser Material D6019-128 outside diameter dimensions re-measured this morning.

Pat